

Work Order ID 111560

January-16-14 8:29:33 AM

111560

Page 1

Item ID: D315-670-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 1/15/14

Start Qty: 400

4

Cust Item ID:

Required Date: 1/15/14

Req'd Qty: 400

4

Customer:

Reference:

Approvals:

Process Plan: MCSDate: 14-01-16 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2432

Rev #

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D315-670-011 CHG001

DAS

6

14-1-27

3x

mha

150

Pick Kit

0.00

150

Packaging

Memo

0.00

Packaging

3x

DAS

28

9-89

14-01-20

DAS

3

9-89

160

QC4- 100% Inspect kits for completeness

0.00

160

QC

Memo

0.00

Quality Control

DAS

6

9-89

14-1-27

3x

Work Order ID 111560

January-16-14 8:29:33 AM

111560

Page 2

Item ID: D315-670-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 1/15/14 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 1/15/14 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>FL</u> <u>011</u>	0.00				<u>\$</u>	<u>3x</u>	<u>8</u>	<u>14-01-27</u>
170							<u>sl</u>		
Packaging	Memo	0.00							
Packaging									
180	QC21 - Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

mcj 14-01-27

(H) 14-01-27

Picklist Print

January-17-14 12:54:39 PM

Page 1

Work Order ID: 111560

Parent Item: D315-670-011

Parent Item Name: Bearpaw

Start Date: 1/15/14

Required Date: 1/15/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 07-01-03 JLM
 IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC IPP RevG: revise seq
 in route DD 10.01.13 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A Bolt		Purchased	No			150	Each	717.0000	12	36	DAS 28 9-89	14-01-20	
-----------------	--	-----------	----	--	--	-----	------	----------	----	----	-------------------	----------	--

Location	Loc Qty	Loc Code
----------	---------	----------

st357	17	
M127432	17	
ST515	700	
M127817	700	

D2182B Seal(\$Per Foot)		Manufactured	No			150	f	250.0200	25	8	DAS 28 9-89	
----------------------------	--	--------------	----	--	--	-----	---	----------	----	---	-------------------	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST412	250.02	
101827	1	
108914	249.02	

D2274 Radius Block		Manufactured	No			150	Each	727.0000	12	36	DAS 28 9-89	
-----------------------	--	--------------	----	--	--	-----	------	----------	----	----	-------------------	--

Location	Loc Qty	Loc Code
----------	---------	----------

FG	12	
86855	12	
ST007	8	
65047	8	
ST008	707	
108466	10	
109534	397	
110264	300	

D2432 Bearpaw 19" X 24"		Manufactured	No			150	Each	0.0000	2	6	DAS 28 9-89	
----------------------------	--	--------------	----	--	--	-----	------	--------	---	---	-------------------	--

DAS
6
9-89

Picklist Print

January-17-14 12:54:40 PM

Page 2

Work Order ID: 111560

Parent Item: D315-670-011

Parent Item Name: Bearpaw

Start Date: 1/15/14

Required Date: 1/15/14

Start Qty: 3.00

Required Qty: 3.00

D2438

Clamp

Manufactured No

150 Each 34.0000

18

B110276

DAS
28
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FG
87532
ST456
108855

4
4
30
30

150 Each 259.0000

36

DAS
28
9-89

D2529

Washer

Manufactured No

DAS
6
9-89

Location

Loc Qty

Loc Code

ST011
108881
109580

259
200
59

150 Each 4,719.0000

36

DAS
28
9-89

MS21042L4

Locknut

Purchased No

DAS
6
9-89

Location

Loc Qty

Loc Code

GA
m126333
ST509
m127255
m127813
ST518
m127376

68
68
4000
2000
2000
651
651

150 Each 7,408.0000

72

DAS
28
9-89

NAS1149D0463J

WASHER

Purchased No

DAS
6
9-89

Location

Loc Qty

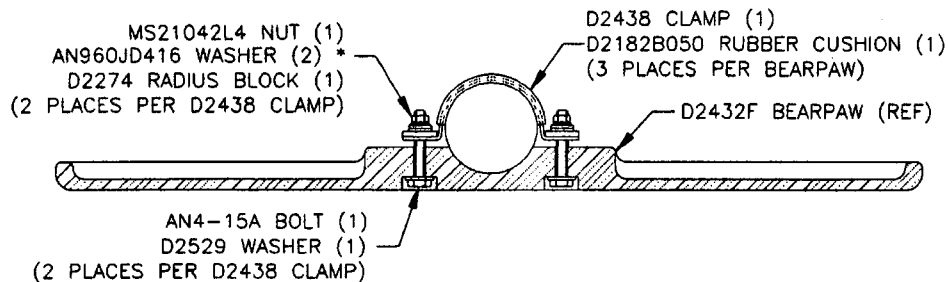
Loc Code

ST294
M127693
ST510a
M127813
M127904

3008
3008
4400
1400
3000

72x

DAS
31
9-89

14-1-23
REFERENCE ON

* Additional AN960JD416 washers may be added to ensure 2-4 threads remaining on bolt.
Figure 3 - Bearpaw Section - Clamp Installation

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D315-670-011 Bearpaw	12.5 lb 5.67 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	146.1 in 3.71 m	1826.3 in-lb 21.03 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D315-670-011	BEARPAW KIT
6	D2182B050	Rubber Cushion
12	D2274	Radius Block
2	D2432F	Bearpaw
6	D2438	Clamp
12	D2529	Washer
12	AN4-17A	Bolt
24	AN960JD416	Washers
12	MS21042L4	Nut (or MS21042-4)